

Date: Friday, 12/2/2005 1:32:54 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 25073	
Estimate Number : 10260	
P.O. Number : N/A	Part Number : D23623
This Issue : 12/2/2005 S.O. No. : N/A	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/1/2005 Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/8/2005 Qty: 2 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : Est: G 00.05.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Take from stock D2362-5 B 13344 X2
 Machine per folio D2362-3 BL 05.12.05

2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2 BL 05.12.05 2

3.0	QC8	SECOND CHECK
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Comment: SECOND CHECK SD 05.12.05 2

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr BL 05.12.05 2

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

MM 05 12 08 2

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

SB 05/12/08 2

Date: Friday, 12/2/2005 1:32:54 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 25073

Part Number: D23623

Job Number:



Seq. #: Machine Or Operation: Description :

7.0 D23971 Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rubber Cushion

Pick:

made by Rand

Qty Part number Description Batch

1 D2397-1 Rubber B16919

SB 05/12/08

8.0 D23973 Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rubber Cushion

Pick:

made by Rand

Qty Part number Description Batch

1 D2397-3 Rubber B16919

SB 05/12/08

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement

as per Dwg D2362

Batch M16194

SB 05/12/08

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2
05/12/08

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 39

16 05/12/08

(2)

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

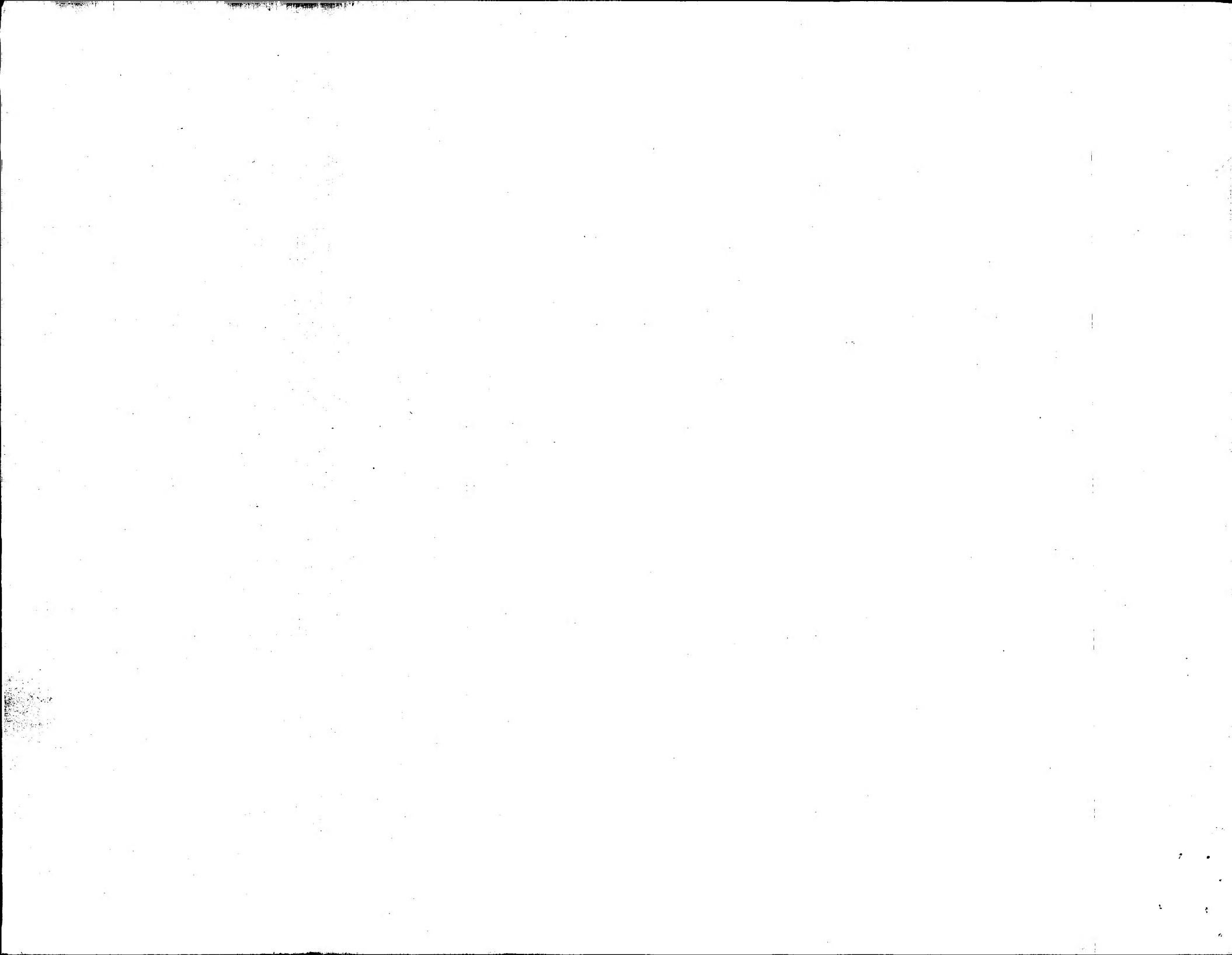
Inspection Level 21

(1) 05/12/08 (2)

Job Completion



u





RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
BW	<i>CP</i>	DRAWING NO.	REV. E
CHECKED <i>KE</i>	APPROVED <i>CP</i>	D2362	SHEET 1 OF 3
DATE 98.12.04		TITLE STEP SUPPORT BRACKET	SCALE 1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

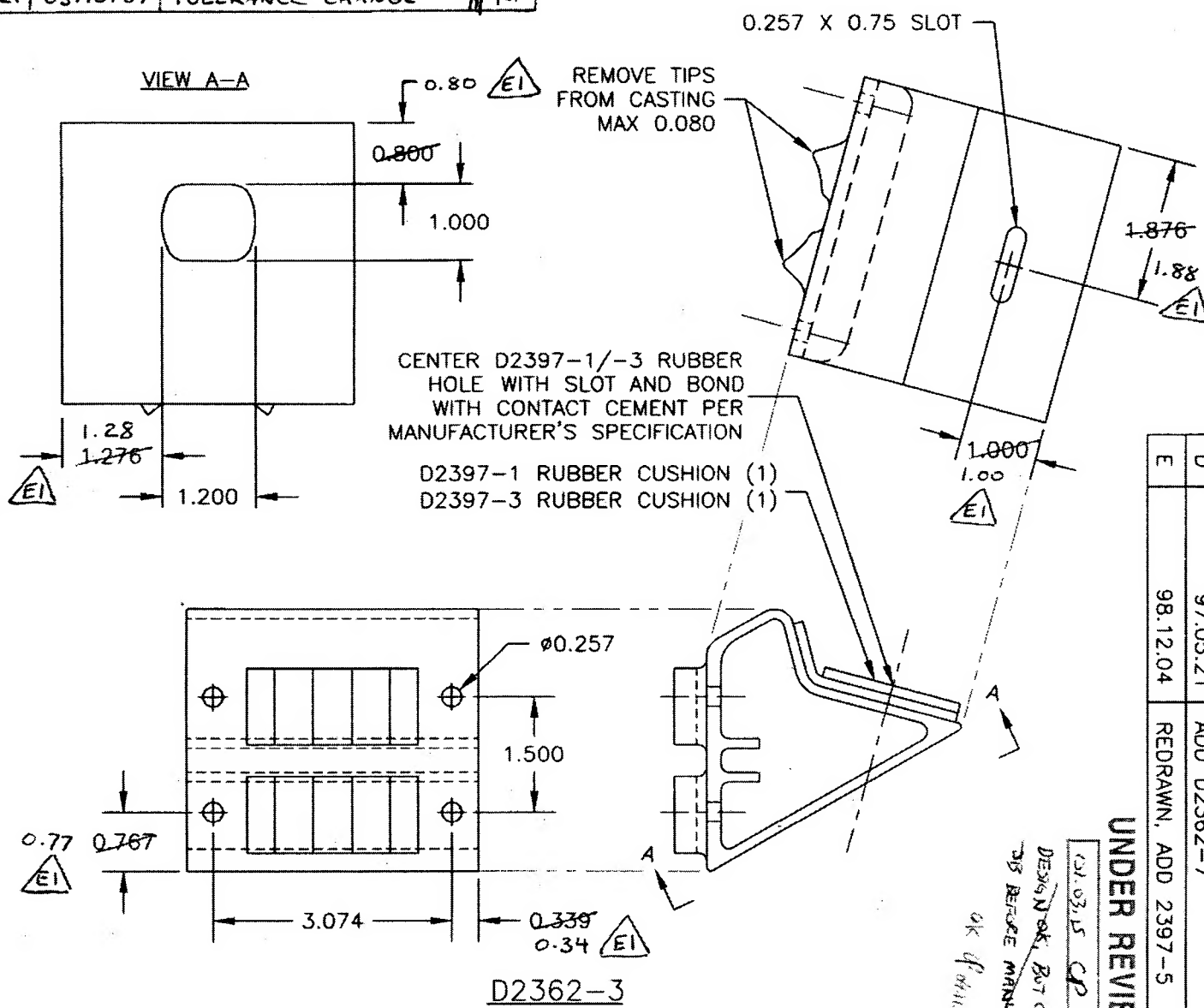
UNDER REVIEW

01.03.15 *CP*

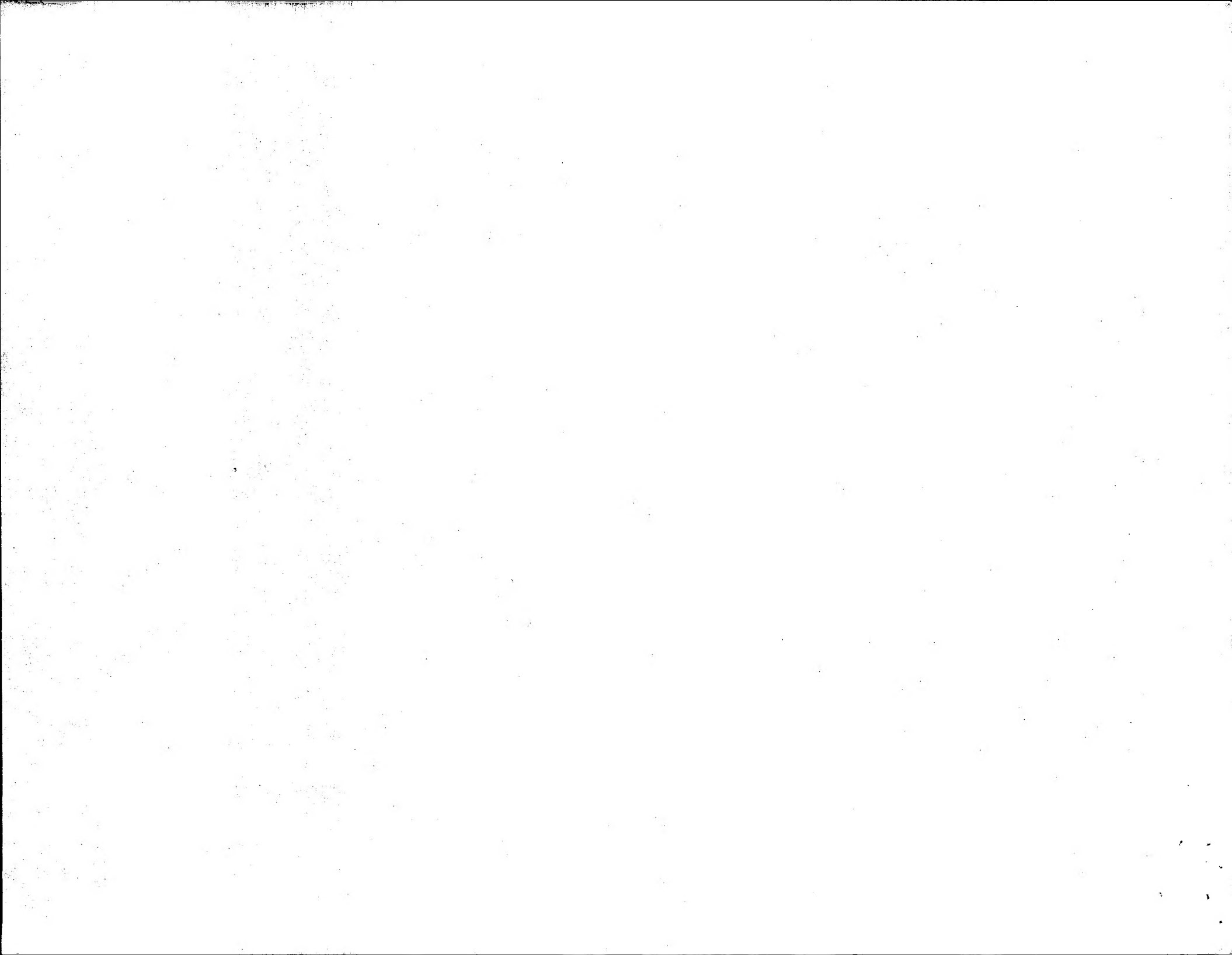
DESIGN OK, BUT CHECK WITH
3B BEFORE MANUFACTURE

OK *CP*

EI 03.10.07 TOLERANCE CHANGE ~~RF~~



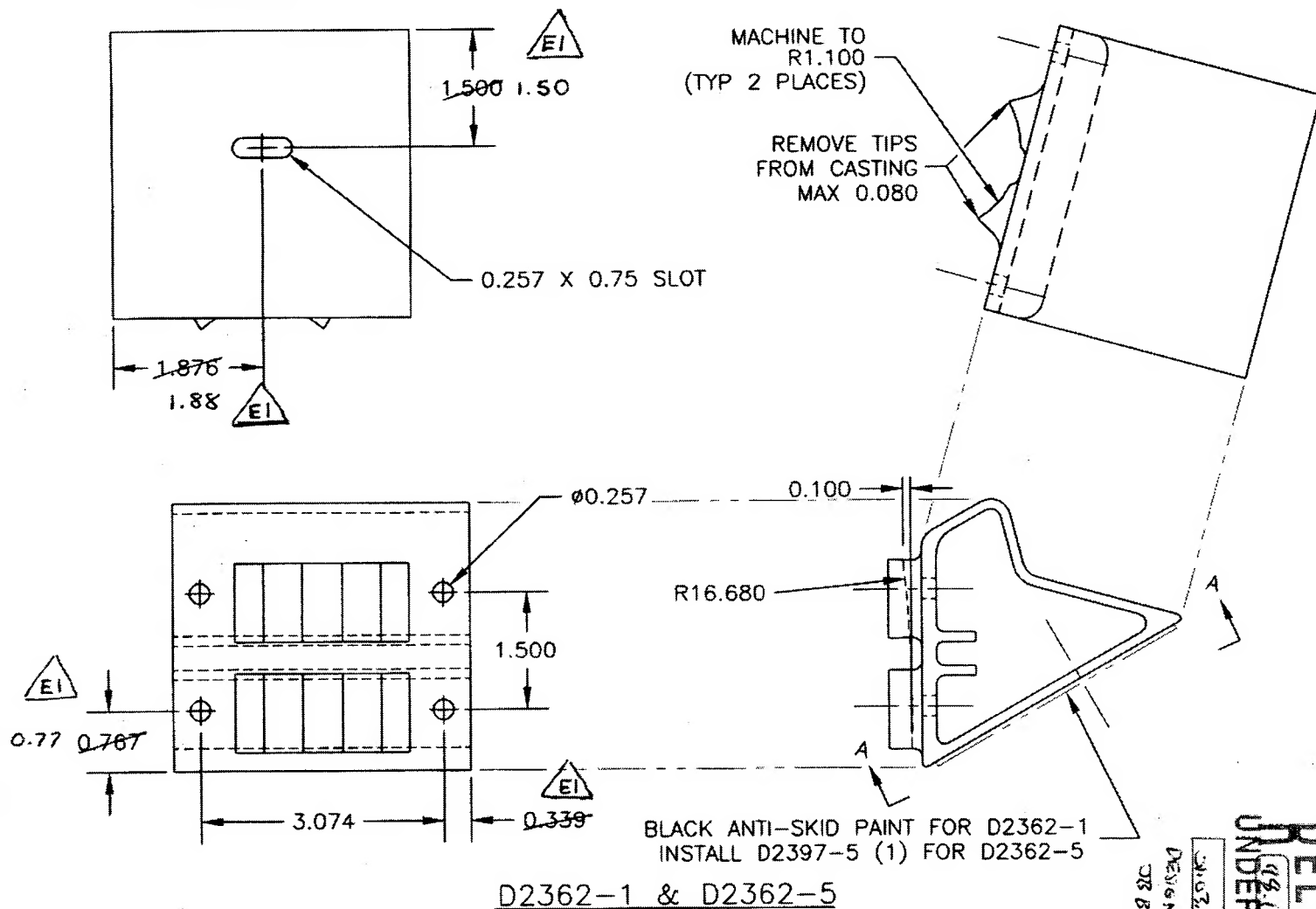
NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED CP	DRAWING NO. D2362
DATE 98.12.04		SHEET 2 OF 3
	TITLE	SCALE
	STEP SUPPORT BRACKET	1:2

VIEW A-A

**NOTES:**

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
98.12.14
UNDER REVIEW
KEDESIGN OK, BUT CHECK BY
DB BEFORE FINAL FACTURE
OK CP 98.12.04

DART



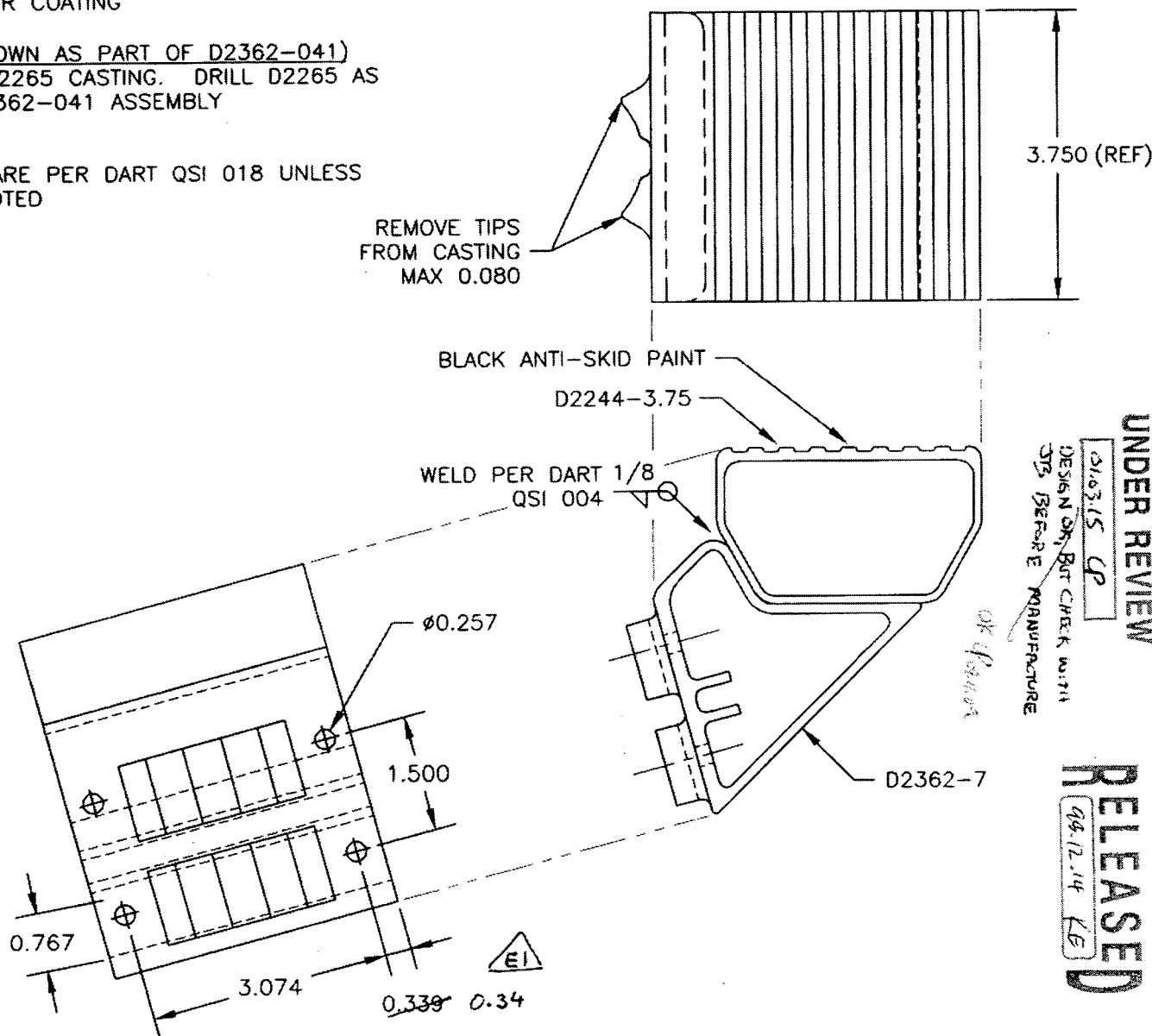
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	APPROVED	HAWKESBURY, ONTARIO, CANADA
CHECKED	DATE	REV. E
98.12.04	98.12.14 KE	SHEET 3 OF 3
	TITLE	SCALE
	STEP SUPPORT BRACKET	1:2

UNDER REVIEW

RELEASED
98.12.14 KE

DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

OK 1/10/04



D2362-041 (SHOWN)
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

Linda Lacelle

From: David Shepherd [davids@dartaero.com]
Sent: Thursday, December 01, 2005 8:11 PM
To: Linda Lacelle
Subject: Re: D2362

Hi Linda,

Looking at drawing D2362 Rev. E1, I think you can take a D2362-5 and convert it into a D2362-3.

You would have to add the 0.257 x 0.75 slot shown on page 1 and convert the existing 0.257 x 0.75 slot shown on page 2 into the 1.00 x 1.20 cutout shown on page 1. Then you would have to machine to remove the R16.68 shown on page 2.

Add the rubber and voila, D2362-3.

Good luck with that. Sorry for not getting back to you sooner.

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>
To: "*David Shepherd (E-mail)" <davids@dartaero.com>
Sent: Thursday, December 01, 2005 7:24 AM
Subject: D2362

>
> David,
> Is there much of a difference from D2362-5 AND D2362-3 ? Can we take a
> D2362-5 and make it into a D2362-3 ?
> LL
>
>
>

